

Date: Thursday, 11/9/2006 4:38:22 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BRACKET
<b>Job Number</b> : 29400	
<b>Estimate Number</b> : 10283	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D31991
<b>This Issue</b> : 11/9/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3199 UNDER REVIEW OK 4001110
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A1
<b>Previous Run</b> : 28830	<b>Material</b> : N/A
<b>Written By</b> : <u>                    </u>	<b>Due Date</b> : 12/10/2006 <b>Qty:</b> 60 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>                    </u>	
<b>Comment</b> : Est Rev:C Removed Scribing 05-11-05 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S20GA	304/316 .040 Sheet
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**Comment:** Qty.: 0.1040 sf(s)/Unit Total : 6.2370 sf(s)

304/316 0.040" SHEET

Batch: m101463

ml 06/11/11

(60)

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

Cut as per Dwg D3199

Dwg Rev: A1

Prog Rev: A1

ml 06/11/11

(60)

Deburr if required

SAD 06/11/19

(60)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/11/11

(60)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

SAD 06/11/13 (60)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Form as per dwg D3199

SB 06/11/22

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 2 Date: 06/12/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/9/2006 4:38:23 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 29400

Part Number: D31991

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MOG/11/23 (60)

7.0

POWDER COATING

POWDER COATING



M19720



Comment: POWDER COATING

POWDER COATING

Powder Coat Gey Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

am YL 06/12/02 X60

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 4/12/11 (60)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 8413

PC 4/12/11 (60)

10.0

QC21

(FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/11

Job Completion



06/12/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

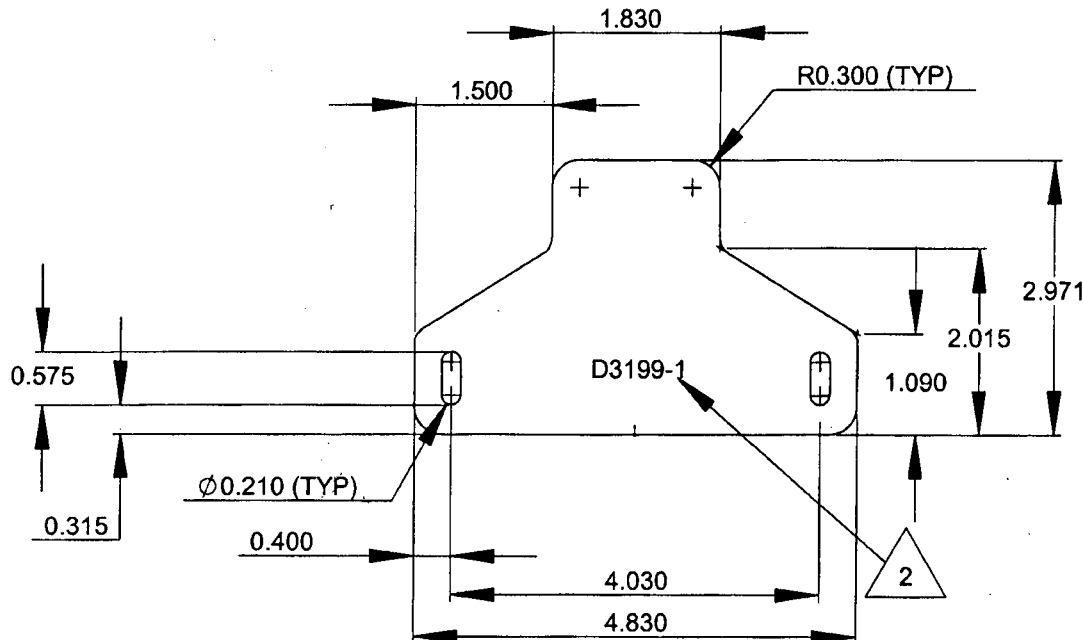
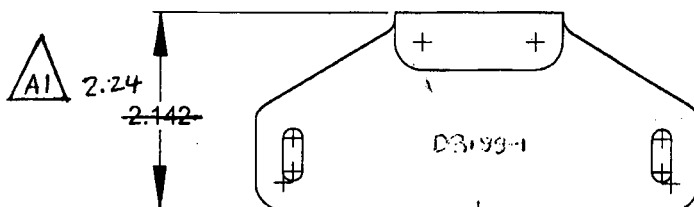
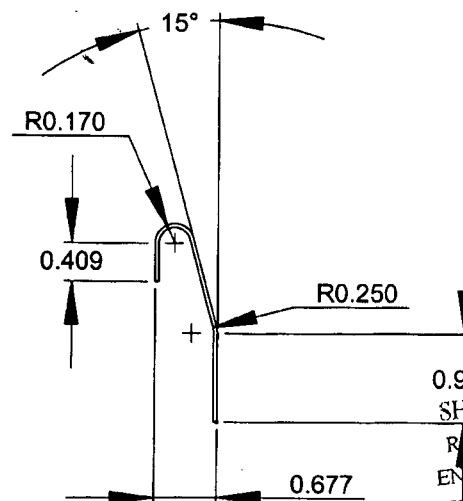
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. <b>D3199</b>	REV. A SHEET 1 OF 1
DATE <b>03.08.05</b>	TITLE <b>BRACKET</b>		SCALE 1:2
A	03.08.05	NEW ISSUE	
AI	04.03.01 <i>A</i>	Z-24 WAS 2.142	

**RELEASED**  
03.09.02 *A***UNDER REVIEW**06.11.01 CB  
add finish**D3199-1 FLAT PATTERN****D3199-1 BRACKET****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S)
- 2) SCRIBE DART P/N D3199-1 AS SHOWN.
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES.

UNCONTROLLED COPY  
SUBJECT TO AMENDMENTNO. 29400  
WORK ORDER  
ANNEALED

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